

Shp 19/04

Work Order ID 67324



Tuesday, March 15, 2011 10:17:40 AM

Item ID: D412-705-017

Accept



Setup Start



Revision ID:

Stop



Item Name: N1 Gearbox Access Panel

Start Date: 3/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-705-017

CHG001

Subs

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/14/15 U

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Subs

XL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 67324

Page 2

Tuesday, March 15, 2011 10:17:40 AM

Item ID: D412-705-017

Accept



Setup Start



Revision ID:

Stop



Item Name: N1 Gearbox Access Panel

Start Date: 3/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-705-

017 □ Location: _____ □ PPP Rev: _____

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/4/19 SP

11/4/19 SP

11-04-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 10:17:46 AM

Page 1

Work Order ID: 67324

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel



Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

AN3C3A

Purchased

No

120

Each

133.0000

30

30 ✓



Bolt

Location

Loc Qty

Loc Code

ST350

133

115159

36

116081

2

116704

95

D3255-041

Manufactured

No

120

Each

0.0000

1

1



Access Panel Assembly

D3255-042

Manufactured

No

120

Each

0.0000

1

1



Access Panel Assembly

MS20427M3-3

Purchased

No

120

Each

220.0000

36

36 ✓



Rivet

Location

Loc Qty

Loc Code

ST318

220

115589

220

JB

116704

66576

68384

117206 11/04/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, March 15, 2011 10:17:46 AM

Work Order ID: 67324

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS21060-L3K

Purchased

No

120

Each

63.0000

18

18 ✓



Nut Plate

Location

Loc Qty

Loc Code

ST302

63

115101

1

115392

1

116082

11

117087

50

MS9321-09

Purchased

No

120

Each

993.0000

30

30 ✓



Washer

Location

Loc Qty

Loc Code

ST296

993

117087

993

117087

JB

JB 11/04/15

Tuesday, March 15, 2011 10:17:46 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.0 PARTS LIST

| Qty -011 | Qty -013 | Qty -015 | Qty -017 | Qty -019 | Qty -021 | Qty -023 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| X | | | | | | | D412-705-011 | TWIN PAK E-Z ACCESS KIT |
| 1 | X | | | | | | D412-705-013 | INTAKE PLENUM ACCESS PANEL KIT |
| 1 | | X | | | | | D412-705-015 | DRIVESHAFT TUNNEL MODIFICATION KIT |
| 1 | | | X | | | | D412-705-017 | N1 GEARBOX ACCESS PANEL KIT |
| 1 | | | | X | | | D412-705-019 | C-BOX OIL COOLER LINE SUPPORT ACCESS KIT |
| 1 | | | | | X | | D412-705-021 | OIL PRESSURE TRANSMITTER ACCESS KIT |
| 1 | | | | | | X | D412-705-023 | OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT |
| | | | | | | | | |
| | 1 | | | | | | D3245-041 | ACCESS PANEL ASSEMBLY, LH |
| | 1 | | | | | | D3245-042 | ACCESS PANEL ASSEMBLY, RH |
| | 2 | | | | | | D3245-043 | DOOR ASSEMBLY |
| | 2 | | | | | | D3245-9 | GASKET |
| | 2 | | | | | | D3245-11 | GASKET |
| | 2 | | | | | | D3245-13 | GASKET |
| | | | 1 | | | | D3255-041 | ACCESS PANEL ASSEMBLY, LH |
| | | | 1 | | | | D3255-042 | ACCESS PANEL ASSEMBLY, RH |
| | | 1 | | | | | D3256-1 | ACCESS PANEL |
| | | 1 | | | | | D3256-3 | GASKET |
| | | | | 1 | | | D3259-041 | ACCESS PANEL ASSEMBLY, LH |
| | | | | 1 | | | D3259-042 | ACCESS PANEL ASSEMBLY, RH |
| | | | | | 1 | | D3307-041 | ACCESS PANEL ASSEMBLY |
| | | | | | | 30 | AN3-3A | BOLT |
| | | 22 | 30 | | 6 | | AN3C-3A | BOLT |
| | | 3 | | | | | AN3C-4A | BOLT |
| | | | | | | 30 | AN960JD10 | WASHER |
| | 16 | 44 | 36 | | 12 | | MS20427M3-3 | RIVET |
| | | | | | | 2 | MS21051-L3K | NUT PLATE |
| | 8 | 22 | 18 | | 6 | | MS21060-L3K | NUT PLATE |
| | | | | | | 18 | MS21069-L3K | NUT PLATE |
| | | 25 | 30 | | 6 | | MS9321-09 | WASHER |

• COPYRIGHT © 2004 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: C

Date: 07.10.12

